



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>mm</i>	APPROVED <i>KE</i>	DRAWING NO. D2610	REV. E SHEET 1 OF 2
DATE 97.09.18		TITLE EC120 STEP ASSEMBLY	SCALE NTS
A	96.10.22	ORIGINAL ISSUE	
B	97.01.14	HAND DRAWING	
C	97.05.09	REVISED MOUNTING LUGS	
D	97.06.04	REVISED FWD END OF STEP	
E	97.09.18	ADDED NUT PLATE	

RELEASED
970125 KE
TSR A450

EFFECTIVE

DEOs

9083	

Qty -041	Qty -042	Part Number	Description
X		D2610-041	STEP ASSEMBLY LH
	X	D2610-042	STEP ASSEMBLY RH
1	1	D2674-3	NUT PLATE
1		D2678-041	STEP WELDMENT LH
	1	D2678-042	STEP WELDMENT RH
1	1	D2682-041	SUPPORT PLATE
1	1	D2683-041	END PLATE
2	2	AN960JD10L	WASHER
2	2	MS20426AD3-5	RIVET
2	2	MS24693-S272*	SCREW
2	2	MS27039-1-09	SCREW
5	5	M7885/3-4- 2 4	RIVET (OR CR3212-4- 2 4)

TSR 1341

00.10.12
CP 00.10.12

*MS24693-C272 SCREWS MAY BE SUBSTITUTED FOR MS24693-S272 SCREWS

DEO'S

9083
97/10/02 KE

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DMY</i>	APPROVED <i>KE</i>	DRAWING NO. D2610	REV. E SHEET 2 OF 2
DATE 97.09.18	TITLE EC120 STEP ASSEMBLY		SCALE 1:15

RELEASED470925 KE
TSR A450

Ø0.128 TRANSFER HOLES FROM STEP
C'SINK Ø0.216 x 100°
M7885/3-4-4 (CR3212-4-4) RIVET (5)
(TOUCH UP WITH ZINC CHROMATE PRIMER PER QSI 005 4.2)

MS24693-S272 SCREWS (2 PLACES)
INSTALL PRIOR TO FINISH

SEAL EDGE OF D2683-041
WITH SILKAFLEX*

AN960JD10L WASHER (1)

MS27039-1-09 SCREW (1)

(2 PLACES)

SEAL WITH SILKAFLEX*

INSTALL PRIOR TO FINISH

D2682-041 MOUNTING PLATE

INSTALL WHILE SEALANT WET

D2674-3 NUT PLATE

D2683-041 END PLATE

POSITION WITH LOCATION

JIG T2610-LJ

MS20426AD3-5 RIVET (2)

0.750 (REF)

DETAIL A

SCALE 1:3

ANTI-SKID SURFACE

D2678-041
OR D2678-042

SEE DETAIL A

D2610-041 SHOWN (L.H.) (USE D2678-041 WELDMENT)
D2610-042 OPPOSITE (R.H.) (USE D2678-042 WELDMENT)

FINISH: - PRIME PER QSI 005 4.2

OR

- POWDER COAT ASSEMBLY TO CUSTOMER SPEC AS PER QSI 005 4.3

- ANTI-SKID TOP PER QSI 005 4.4 (MASK TO BOTTOM OF RADIUS)

OR

- PAINT ASSEMBLY TO CUSTOMER SPEC AS PER QSI 005 4.2

- ANTI-SKID TOP PER QSI 005 4.4 (MASK TO BOTTOM OF RADIUS)

*NOTE: SILKAFLEX-241 ADHESIVE
PER MANUFACTURER'S SPECIFICATION
POSSIBLE VENDOR: PAYNE'S MARINE SUPPLY